

CLAIMS

1. A process for depositing a zincate coating on aluminum or aluminum based alloy substrates which comprises

- 5 (A) immersing an aluminum or aluminum based alloy substrate in an aqueous alkaline zincate solution comprising hydroxide ions, zinc ions, nickel and/or cobalt ions, iron ions, copper ions and at least one inhibitor containing one or more nitrogen atoms, one or more sulfur atoms, or both sulfur and nitrogen atoms provided said nitrogen atoms are not present in an aliphatic amine or hydroxylamine for a period of time sufficient to deposit the desired coating, and
- 10 (B) removing the coated substrate from the zincate solution.

2. The process of claim 1 wherein the surface of the aluminum or aluminum based alloy is cleaned, etched and desmuted prior to immersion in the

15 zincate solution.

3. The process of claim 2 wherein the cleaning is performed with an alkaline cleaner, and the etching is performed with an alkaline or acid etching solution.

20 4. The process of claim 1 wherein after immersion in the zincate solution to form a first zincate coating, the coated aluminum or aluminum alloy is withdrawn from the zincate solution, the coating is at least partially stripped with acid, and the aluminum or aluminum alloy is re-immersed in the zincate solution to form a second

25 zincate coating.

5. The process of claim 4 wherein the aluminum or aluminum alloy is rinsed with water after each of the cleaning, etching, desmutting, zincating and stripping with acid steps.

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6. A zincate coated aluminum or aluminum alloy obtained in accordance with the process of claim 1.

7. A process for depositing a zincate coating on aluminum or aluminum based alloy substrate which comprises

(A) immersing the substrate in an aqueous alkaline zincate solution comprising hydroxide ions, zinc ions, nickel and/or cobalt ions, iron ions, copper ions, nitrate ions, at least one inhibitor containing nitrogen atoms, sulfur atoms, or both sulfur and nitrogen atoms provided said nitrogen atoms are not present in an aliphatic amine or aliphatic hydroxylamine, and at least one metal complexing agent for a period of time sufficient to deposit the desired coating, and

(B) removing the coated substrate from the zincate solution.

8. The process of claim 7 wherein the surface of the substrate is cleaned, etched and desmutted prior to immersion in the zincate solution.

9. The process of claim 8 wherein the cleaning is performed with an alkaline cleaner, and the etching is performed with an alkaline or acid etching solution.

10. The process of claim 7 wherein after immersion in the zincate solution to form a first zincate coating, the coated substrate is withdrawn from the zincate solution, the coating is at least partially stripped with acid, and the aluminum or aluminum alloy is re-immersed in the zincate solution to form a second zincate coating.

11. The process of claim 10 wherein the substrate is rinsed with water after each of the cleaning, etching, desmutting, zincating and stripping with acid steps.

12. A zincate coated aluminum or aluminum alloy obtained in accordance with the process of claim 7.

13. A process for depositing a zincate coating on aluminum or aluminum based alloy substrate which comprises

(A) immersing the substrate in an aqueous alkaline zincate solution comprising:

from about 5 to about 300 g/l of hydroxide ions,

from about 1 to about 30 g/l of zinc ions,

from about 0.1 to about 5.0 g/l of iron ions,

from about 0.01 to about 10 g/l of copper ions,

from about 0.05 to about 20 g/l of nickel and/or cobalt ions,

from about 0.001 to about 10 g/l of an inhibitor

from about 0.01 to about 10 g/l of an alkali metal nitrate, and

from about 1 to about 250 g/l of at least one metal complexing agent for a period of time sufficient to deposit the desired coating, and

(B) removing the coated substrate from the zincate solution.

14. The process of claim 13 wherein the surface of the substrate is cleaned, etched and desmuted prior to immersion in the zincate solution.

15. The process of claim 14 wherein the cleaning is performed with an alkaline cleaner, and the etching is performed with alkaline or acid etching solution.

16. The process of claim 13 wherein after immersion in the zincate solution to form a first zincate coating, the coated substrate is withdrawn from the zincate solution, the coating is at least partially stripped with acid, and the aluminum or aluminum alloy is re-immersed in the zincate solution to form a second zincate coating.

17. The process of claim 16 wherein the substrate is rinsed with water after each of the cleaning, etching, desmutting, zincating and stripping with acid steps.

5 18. A zincate coated aluminum or aluminum alloy obtained in accordance with the process of claim 11.

19. A process for depositing a metal coating on an aluminum or aluminum alloy substrate comprising

10 (A) applying an immersion zincate coating on the substrate by immersing the substrate in an aqueous alkaline zincate solution comprising hydroxide ions, zinc ions, nickel and/or cobalt ions, iron ions, copper ions and at least one inhibitor containing one or more nitrogen atoms, one or more sulfur atoms, or both sulfur and nitrogen atoms provided said nitrogen atoms are not present in an aliphatic amine or hydroxylamine, and

15 (B) plating the zincate coated substrate using an electroless or eletrolytic metal plating solution.

20 20. The process of claim 19 wherein the surface of the substrate is subjected to alkaline cleaning, acid etching and desmutting, prior to immersion in the zincate solution.

21. The process of claim 20 wherein the cleaning is performed with an alkaline cleaner, and the etching is performed with alkaline or acid etching solution.

25 22. The process of claim 19 wherein after immersion in the zincate solution to form a first zincate coating, the coated substrate is withdrawn from the zincate solution, the coating is at least partially stripped with acid, and the aluminum or aluminum alloy is re-immersed in the zincate solution to form a second zincate coating.

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23. The process of claim 22 wherein the substrate is rinsed with water after each of the cleaning, etching, desmutting, zincating and stripping with acid steps.

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24. A metal coated aluminum or aluminum alloy obtained in accordance with the process of claim 19.